

Work Order ID 60798

Friday, July 23, 2010 8:06:13 AM



Page 1

Item ID: D4151-7

Accept



Setup

Start



Revision ID:

Item Name: Fwd Eyebolt Receiver (Upper)

Stop



Start Date: 7/23/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-7-23 Tooling:

Date:

Run

Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4151

B

100



Bandsaw

Memo

0.00

10/07/27

4 0

Jeaspa Bandsaw

Cut blank to 2.885" long

110



HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

10/07/27

4 0

1-MILL as per folio FA952 & dwg,  
FOLIO REV: B  
DWG REV: B

2-Deburr as required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 60798**

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Item ID: D4151-7

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Stop



Start Date: 7/23/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

B.A 10/07/27

4 0

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

SD 10/07/27

4 0

140



Packaging

Packaging

Identify as per dwg & Stock Location: GA

0.00

B60787

0.00

SB 10/07/27

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 60798**

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Page 3

Item ID: D4151-7

Accept



Setup Start



Revision ID:

Item Name: Fwd Eyebolt Receiver (Upper)



Cust Item ID:

Start Date: 7/23/2010 Start Qty: 4.00

Stop



Required Date: 7/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

150



QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInspec.  
Stamp

Memo

0.00

10/07/28 AF

H10-7-28  
(4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Friday, July 23, 2010 8:06:17 AM

Page 1

Work Order ID: 60798



Parent Item: D4151-7



Parent Item Name: Fwd Eyebolt Receiver (Upper)

Start Date: 7/23/2010

Required Date: 7/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B2.000X1.750 303 BAR 2" X 1.750"		Purchased		No			f	19.1659	0.26	1.094737			

Location	Loc Qty	Loc Code
MAT	18.8534	
115047	18.8534	
MAT53	0.31251	
113310	0.31251	

1.0947 *out 10/07/27*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	60798
Description: FWD EYEBOLT RECEIVER (UPPER)		Part Number:	DA1151-7
Inspection Dwg: DA1151 Rev: B		Page 1 of 1	

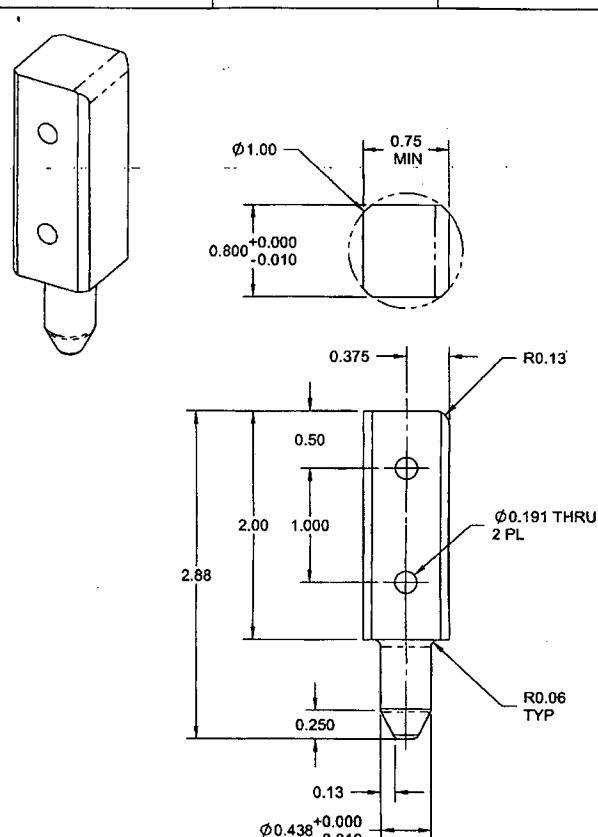
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.250	+/- .010	1.248	✓		VERN	GA-01
1.250	+/- .010	1.249	✓		" "	
0.09X45°	+/- .030	0.100X45°	✓		" "	
1.00	+/- .030	1.000	✓		" "	
R0.13	+/- .030	R0.130	✓		" "	
Ø0.191	+0.005/-0.001	Ø0.192	✓		" "	
R0.19	+/- .030	R0.188	✓		" "	
0.96	+/- .030	0.960	✓		" "	
0.09X45°	+/- .030	0.092X45°	✓		" "	
0.350	+/- .010	0.351	✓		" "	
Ø0.257	+0.006/-0.001	Ø0.258	✓		" "	
1.110	+/- .010	1.110	✓		" "	
1.000	+/- .010	1.000	✓		" "	
2.76	+/- .030	2.760	✓		" "	
0.225	+/- .010	0.226	✓		" "	
0.800	+0.000/-0.010	0.797	✓		" "	
1.80	+/- .030	1.797	✓		" "	
0.88	+/- .030	0.904	✓		" "	
0.09X45°	+/- .030	0.100X45°	✓		" "	
Ø0.734	+0.010/-0.000	Ø0.737	✓		" "	

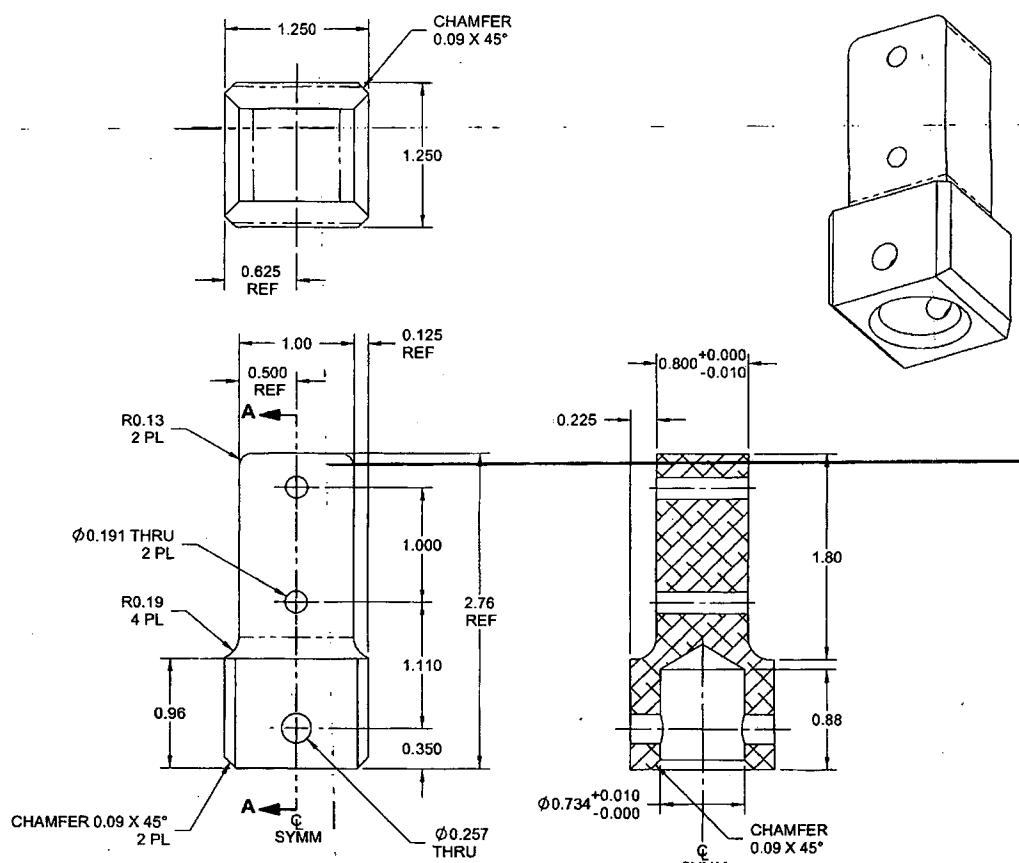
Measured by:	J. A	Audited by:	SJ	Preliminary Approval:	
Date:	10/07/17	Date:	10/07/17	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*[Handwritten Signature]*



**B D4151-5 FWD BASKET INSTL STUD (LOWER)**



**D4151-7 FWD EYEBOLT RECEIVER (UPPER)**

**SECTION A-A**

RELEASED  
2010-07-16

## NOTES:

**NOTES:**

1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582  
PER DART SPEC M303R OR M304R  
-7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582  
PER DART SPEC M303B OR M304B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY AT ASSEMBLY

7) WEIGHT -5: 0.36 lbs  
-7: 0.70 lbs

5 SHOP COPY 4  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 6078

NO. 1000  
BD 00-7-23

DESIGN	<u>13</u>	DART AEROSPACE LTD		
DRAWN	<u>13</u>	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<u>13</u>	DRAWING NO.	REV. B	
MFG. APPR.	<u>13</u>	D4151	SHEET 3 OF 3	
APPROVED	<u>13</u>	TITLE	SCALE	
DE APPR.	<u>13</u>	BASKET FWD HARPOON	NTS	
DATE	10:07:05	COPYRIGHT © 2019 BY DART AEROSPACE LTD		
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